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RBE350A93-3303-02
Job Sheet 193177



Part No: RBE350A93-3303-02

Job Qty: 16 pcs

Part Name: Tail Rotor Head Body Extractor Tool



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/9/19

Job Tracking No:

Due Date: 5/6/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: RBE350A93-3303-02 REV 4 IPP REV A 18-01-17 NEW ISSUE JFC VERIFIED DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	16 pcs	5/6/19	5/6/19	0.08	16.00	External Load - 1		
							External Load - 2		
							External Load - 3		
							Small Fab - 1		
							Small Fab - 2		M2L
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	QC 5	16 pcs	5/6/19	5/6/19	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
130	Packaging 3-1 - Stock - B4B	16 pcs	5/6/19	5/6/19	0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		



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Container No: S186477



Part: RBE350A93-3303-02

Job No: 193177

Serial No/Batch: S186477

Revision: 4

Inspector:

Exp Date:

Instructions:

Date: 06/03/19

DAS
40
9-89

JUN 03 2019

Plex 4/9/19 11:18 AM Dart.lajeunesse.marie

				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	DAS
				Packaging 3 - 7 - B4B	28
				Packaging 3 - 8 - B4B	9-89
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140	QC 21 - FG	16 pcs	5/6/19	0.00 0.00	QC 21 - FG - 21
					QC 21 - FG - 70
					QC 21 - SA - 53

Part Op **100** - (Small Fab) - Assemble as per DWG. Sheet 1 - Loctite 262/263 B M138904 Exp: 4/20
 Descriptions: **110** - (QC5- Inspect part completeness to step on W/O)
130 - (Identify as per dwg & Stock Location: _____)
140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
91030A031	Flange Hex Nut	32 Ea (2 ea)	100-Small Fab - 1	5X 508 1653
RBE350A93-3303-02-1	Receiver	16 pcs (1 ea)	100-Small Fab - 1	9X 5145 158
RBE350A93-3303-02-3	Extractor	16 pcs (1 ea)	100-Small Fab - 1	6X 5144 721 1X 5109 781
RBE350A93-3303-02-5	Extractor Pin	16 pcs (1 ea)	100-Small Fab - 1	50 76 784
RBE350A93-3303-02-7	Stud	32 pcs (2 ea)	100-Small Fab - 1	4X 5102 649 2X 5168 918

Job Allocations

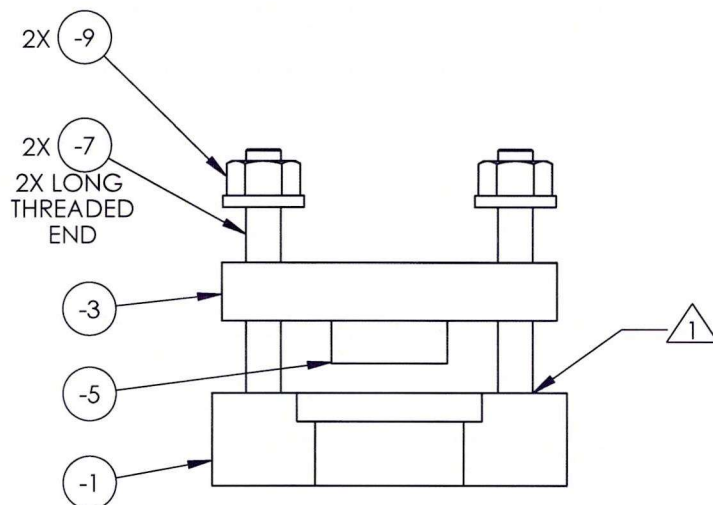
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	91030A031	32	31	0
	RBE350A93-3303-02-1	16	12	0
	RBE350A93-3303-02-3	16	11	0
	RBE350A93-3303-02-5- <u>PD</u>	16	10	0
	RBE350A93-3303-02-7	32	14	0

Part Specifications

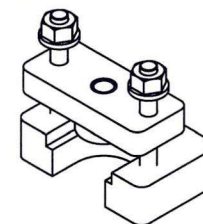
Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		CH'D FROM HEX BOLTS & SET SCREWS TO STUDS. -1 ADDED R.25 TO CORNERS. -3 CH'D HOLES FROM Ø.413 AND ADDED R.25 TO CORNERS.	12/4/2008	WP	DW
2		-11 ADDED LOCTITE TO BOM. -5 ADDED .03 X 45° CHAMFER.	12/4/2008	WP	DW
2A		CORRECTED T/N AND TOOL NAME WAS RBEA93-3303-02, T/R HUB BODY EXTRACTOR TOOL IS RBE350A93-3303-02, T/R BODY EXTRACTOR TOOL.	11/5/2013	RJC	RW
3		-3 CH'D DIMS WAS Ø.500 IS LIMITS Ø.5000 - .5005, WAS .630 IS (.625). -5 CH'D DIM WAS Ø.501 IS Ø.5010 - .5015. -9 CH'D WAS SWIVEL HEX NUT #90477A031 IS FLANGE HEX NUT #91030A031.	3/13/2014	DPD	GE
4	15-0132	-1 & -3 CH'D MATERIAL WAS 1018 IS A36/1018/1020. -5 CH'D MATERIAL WAS 4140 G&P IS 4140/4142 Q&T.	6/10/2015	RJC	JAG



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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 193177 MJS
19-04-09



NOTE:

△ 2X LOCTITE ON THREADS -7 TO -1.

DART AEROSPACE	
TITLE T/R BODY EXTRACTOR TOOL	
DWG NO. RBE350A93-3303-02	REV 4
MAT'L UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XX ± .005 FRACTIONS ± 1/8 .XX ± .01 ANGLES ± 5° .X ± .1	DRAWN BY: PERRITT APPROVED: <i>D Weil</i> HEAT TREAT FINISH SPEC
1. BREAK ALL SHARP EDGES .015 x 45° OR .015R 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	USED ON MODEL EUROCOPTER AS350A
SCALE 1:2	DATE 10/27/2008 SHEET 1 OF 5

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
			-1	1	RECEIVER	A36/1018/1020		2
			-3	1	EXTRACTOR	A36/1018/1020		3
			-5	1	EXTRACTOR PIN	4140/4142 Q&T		4
			-7	2	STUD	STEEL	3/8-16 UNC-2A X 4 (MCMASTER-CARR #90281A640) MODIFIED	5
		B/O	-9	2	FLANGE HEX NUT	STEEL	3/8-16 UNC-2B (MCMASTER-CARR #91030A031)	1
		B/O	-11	AR	262 LOCTITE		(MCMASTER-CARR #91458A180)	N/S

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					